

Work Order ID 70695

Monday, June 13, 2011 1:34:41 PM



Page 1

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 6/13/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject. Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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100		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program Batch No. 70695 Double check by: B.A. <input type="checkbox"/> 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets <input type="checkbox"/> 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets <input type="checkbox"/> 3-Machine Step No 3 per Folio FA641 and inspect p								

and 11/10/30
B.A. 11/11/01

20 *φ*

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

and 11/10/30
B.A. 11/11/01

20 *φ*

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

11-11-2

20 *φ*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70695

Monday, June 13, 2011 1:34:41 PM



Page 2

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 6/13/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20 BR 11-11-3

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

MU8439

3200F

11:30

12:00

20 XJ M/L 4/11/03

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 BR 11-11-3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70695

Monday, June 13, 2011 1:34:41 PM



Page 3

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 6/13/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 85424 0.00

Packaging

Memo

0.00

Packaging

80 11-11-03

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/07 11-11-04
(20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 1:35:27 PM

Page 1

Work Order ID: 70695



Parent Item: D3500-1



Parent Item Name: Saddle



Start Date: 6/13/2011

Required Date: 6/20/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 		Manufactured	No			100	Each	12.0000	1	20			
Saddle Billet													

Location

Loc Qty

Loc Code

MAT043

12

59467

3

60713

8

61300

1

73492 X20

and 11/10/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	70695
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.500	.499	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.587	1.586	1.585		
J	0.240	0.260		.244	.244	.245	.245		
K	0.490	0.510		.500	.499	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.549	.549	.500		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.045	.045	.045	.045		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.132	1.132	1.132	1.131		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.250	.250	.257		
AE	1.810	1.830		1.818	1.817	1.817	1.818		
AF	0.240	0.260		.245	.246	.245	.245		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.148	.147	.148	.148		
AI	0.140	0.160		.154	.155	.153	.153		
Accept/Reject									

Measured by:	omf
Date:	11/10/30

Audited by:	RR
Date:	11.11.2

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	70695
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.589	1.587	1.586		
J	0.240	0.260		.244	.245	.245	.244		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.570	6.570	6.570	6.570		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.549	.550	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.048	.048	.048	.048		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.132	1.135	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.810	1.830		1.818	1.819	1.819	1.818		
AF	0.240	0.260		.246	.248	.246	.246		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.148	.148	.148	.148		
AI	0.140	0.160		.154	.154	.155	.155		
Accept/Reject									

Measured by: <u>CMR</u>	Audited by: <u>RP</u>
Date: <u>11/10/31</u>	Date: <u>11-11-2</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order:	70695
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1/9	2/10	3/11	4/12		
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.586	1.587	1.587		
J	0.240	0.260		.244	.244	.244	.244		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.549	.549	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.047	.045	.048	.045		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.133	1.132	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.257	.250	.250		
AE	1.810	1.830		1.818	1.817	1.818	1.817		
AF	0.240	0.260		.246	.245	.246	.246		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.148	.147	.147	.148		
AI	0.140	0.160		.154	.155	.155	.155		
Accept/Reject									

Measured by:	cmr
Date:	11/10/31

Audited by:	RR
Date:	11.11.2

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order:	70695
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13	2/14	3/15	4/16		
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.381	.381	.381	.381		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.587	1.586		
J	0.240	0.260		.244	.244	.244	.244		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.500	6.500	6.500	6.500		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.550	.549	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.045	.045	.047	.046		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.133	1.133	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.249	.249	.249		
AE	1.810	1.830		1.818	1.818	1.818	1.818		
AF	0.240	0.260		.246	.246	.246	.246		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.147	.148	.148	.147		
AI	0.140	0.160		.154	.155	.155	.155		
Accept/Reject									

Measured by:	cmf	Audited by:	20
Date:	11/10/31	Date:	11-11-2

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order:	70695
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1/7	2/8	3/9	4/20		
A	0.483	0.490		.487	.487	0.487	0.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	0.383	0.383		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.585	1.587	1.590		
J	0.240	0.260		0.247	0.247	0.247	0.247		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	0.317	0.317		
N	0.256	0.262		.260	.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.551	0.551	0.551	0.551		
V	0.793	0.803		.798	.798	0.798	0.798		
W	R.240	R.260		.250	.250	0.250	0.250		
X	0.040	0.060		0.045	0.045	0.045	0.045		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.132	1.132	1.132	1.134		
AB	R.490	R.510		.500	.500	0.500	0.500		
AC	0.615	0.635		.635	.635	0.635	0.635		
AD	0.240	0.260		0.250	0.252	0.257	0.251		
AE	1.810	1.830		1.818	1.812	1.818	1.817		
AF	0.240	0.260		0.247	0.247	0.248	0.248		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.157	0.157	0.157	0.157		
AI	0.140	0.160		0.154	0.155	0.154	0.154		
Accept/Reject									

Measured by:	cmf / DA
Date:	11/10/31 / 11/11/01

Audited by:	RP
Date:	11.11.2

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

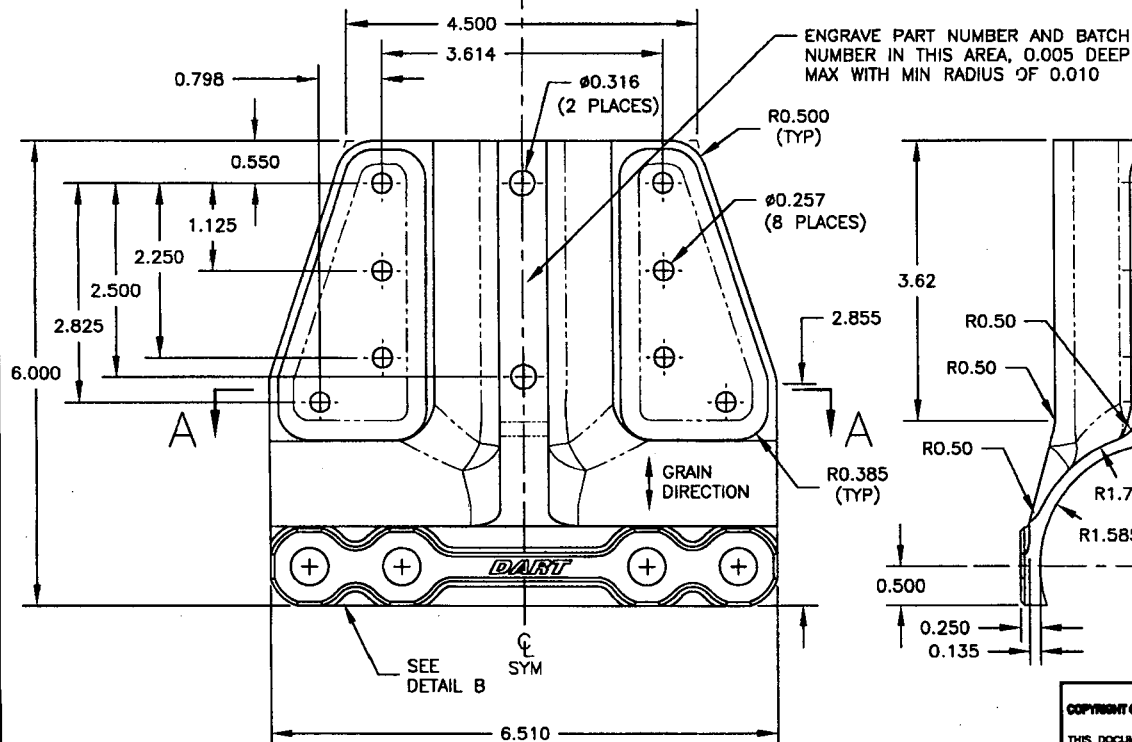
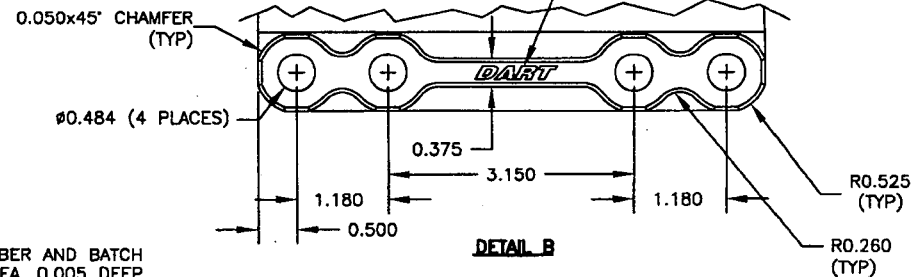
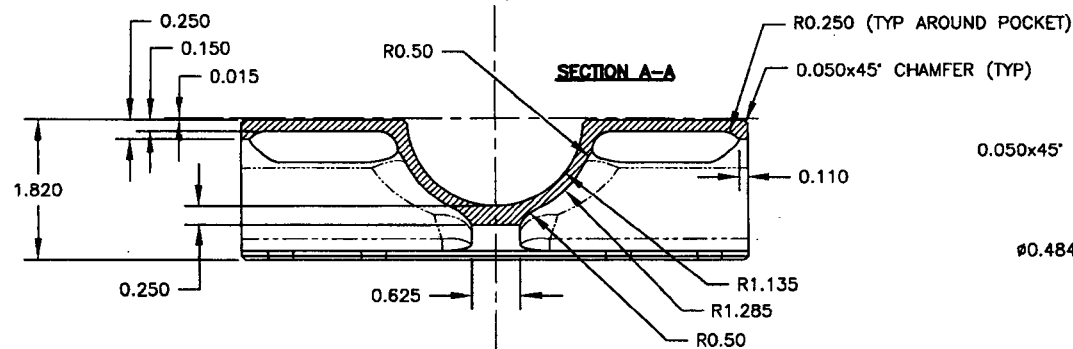
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 70695

ENGRAVE DART LOGO IN
THIS AREA TO A MAX
DEPTH OF 0.015 AND A MIN.
TOOL RADIUS OF 0.250



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-68-15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD. WARRICKBURT, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3500
DATE	06.06.30	TITLE SADDLE
REV. C		SHEET 1 OF 1
		SCALE 2:3

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DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries